

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017935**Date Inspected:** 07-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

Bay 1

This QA Inspector observed the following work in progress for Bay 1.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Shen Jian Guo.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Traveler Rail

PCMK: B 9TR2-002-017

Welder: 216872

WPS-B-T-2231-TC-U5-F

Heat straightening of PCMK, 20TR2-046, 031 under approved Heat Straightening procedure, HSR(B)-362. The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Ai Wei. The approved HSR procedure stated that a maximum temperature of 650°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 8mm.

Bay 2

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This QA Inspector observed the following work in progress for Bay 2.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Ai Wei.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Floor beam

PCMK: FB3328-001-053

Welder: 045209

WPS-B-T-2232-TC-U4b-F

PCMK: FB3328-001-016

Welder: 047866

WPS-B-T-2232-TC-U4b-F

PCMK: FB3328-001-036

Welder: 202122

WPS-B-T-2232-TC-U4b-F

Components: Bulk Head

PCMK: SA3409-001-016

Welder: 048096

WPS-B-T-2232-TC-U4b-F

Components: Barrier Rail

PCMK: E2-SB1-009-027,028

Welder: 045203

WPS-B-T-2132-3

Components: Vertical Plate

PCMK: VP3014-001-028

Welder: 045240

Report: B-WR15422

WPS-345-FCAW-2G (2F)-FCM-Repair

Heat straightening of PCMK, VP3012-002,004,005~019, LD3050 and E5-SB1-041 under approved Heat Straightening procedure, HSR (B)-421, HSR1(B)-94512, 9505. The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Ai Wei. The approved HSR procedure stated that a maximum temperature of 600°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 45mm, 6mm, and 16mm.

Bay 3

This QA Inspector observed the following work in progress for Bay 3.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

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ZPMC QC is identified as Ai Wei.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Floor beam

PCMK: FB3286

Welder: 206623, 055564, 044830

Report: B-CWR1822

WPS-B-T-2232-TC-U4b-F

Heat straightening of PCMK, FB3260-001 under approved Heat Straightening procedure, HSR 1 (B)-9523. The in process temperature was at the time of this observation witnessed at less than 600°C. The ZPMC QC was identified as Zhu Jun. The approved HSR procedure stated that a maximum temperature of 600°C with 1-3 applications. The distortion that was previously measured and recorded on the HSR was Maximum 13mm.

Bay 6

This QA Inspector observed the following work in progress for Bay 6.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Huang Min.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Components: Floor beam

PCMK: FB3002J-002-027

Welder: 053609

WPS-B-T-2232-TC-U5-F

PCMK: FB3002K-003-027

Welder: 217185

WPS-B-T-2232-TC-U5-F

Components: West Jacking Frame

PCMK: WJF-0-1201-709, 710, 711

Welder: 215083

WPS-B-T-3312-TC-P4 and WPS-B-T-3112-1

PCMK: WJF-0-1901-706, 707, 708

Welder: 049769

WPS-B-T-3312-TC-P4 and WPS-B-T-3112-1

Bay 7

This QA Inspector observed the following work in progress for Bay 7.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Wang Lin.

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Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components: Floor beam
PCMK: FB3244-001-005
Welder: 053742
WPS-B-T-2233-TC-U4b-F

PCMK: FB3246-001-017
Welder: 204342
WPS-B-T-2233-TC-U4b-F

Components: Cross beam
PCMK: CB3003B-019-002
Welder: 215689
WPS-B-T-2231-B-U2-F

Components: Deck Plate
PCMK: DP3165-001-157
Welder: 051246
WPS-B-T-2231-B-U2-F

Components: Anchor Plate
PCMK: AP3025-001-267
Welder: 048625
WPS-B-T-2232-TC-U4b-F

Bay 8

This QA Inspector observed the following work in progress for Bay 8.
ZPMC was using the Shield Metal Arc Welding (SMAW) process.
ZPMC QC is identified as Wang Lin.

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).
Listed below are the locations that were identified by this QA inspector.

Components: Bike Path
PCMK: BK0044A1-055-043
Welder: 040673
Report: B-WR15479
WPS-345-SMAW-2G (2F)-Repair

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Shin,DJ	Quality Assurance Inspector
Reviewed By:	Carreon,Albert	QA Reviewer
